

Work Order ID 69325

Monday, May 09, 2011 9:05:50 AM

Page 1

Item ID: D2597

Accept

Setup Start

Revision ID:

Stop

Item Name: 204 Web

Start Date: 5/9/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2597

Rev D

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut D2500-3 to length: 84.25" ☐ Use Jig DT8094 to drill pilot holes. ☐ Open to 0.625 diameter using a uni-bit.

2 0 BB 11/05/09

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

2 0 BB 11/05/09

120

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

2 0 BB 11/05/09

Work Order ID 69325

Monday, May 09, 2011 9:05:50 AM



Page 2

Item ID: D2597

Accept



Setup Start



Revision ID:

Stop



Item Name: 204 Web

Start Date: 5/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2

0

BB 11/05/09

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

2

BB 11/05/09

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18 J

11-05-18
2

Picklist Print

Monday, May 09, 2011 9:05:45 AM

Page 1

Work Order ID: 69325



Parent Item: D2597

Parent Item Name: 204 Web

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D□98.10.15□Eliminated DEO, Changed Dwg Revision□KS□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2500-3-100

Manufactured

No

110

Each

157.0000

1

2



Ext'n - I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

157

51957

4

66298

153

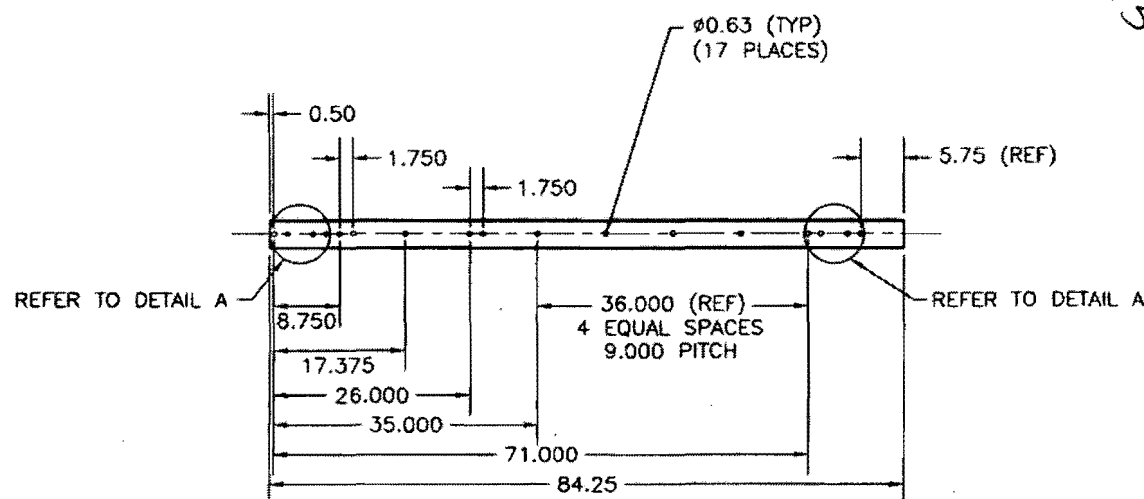
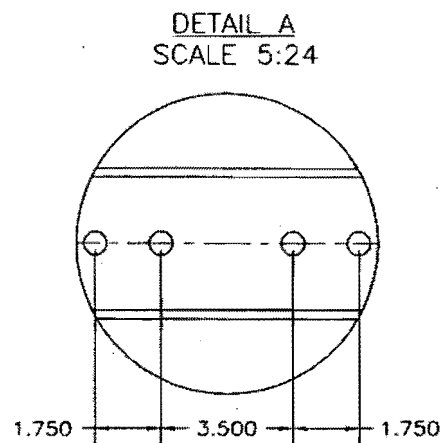
2

BB 11/05/18



RELEASED
98.9.11 JS

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 98.09.14	DRAWING NO. D2597	REV. D
	TITLE 204 WEB	SHEET 1 OF 1
		SCALE 1:24
A	96.09.16	NEW ISSUE
B	96.10.29	5.75 WAS 0.50
C	97.07.23	Ø0.63 WAS Ø0.56
D	98.09.14	INCORPORATED DEO 9097



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED